

Date: Thursday, 3/13/2008 10:25:19 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	CHAFING SHIELD
Job Number	37969			
Estimate Number	11138			
P.O. Number	:		Part Number	: D31901
This Issue	: 3/13/2008	S.O. No. :	Drawing Number	: D3190 REV A
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 37343		Material	:
Written By	:		Due Date	: 3/19/2008 Qty: 20 Um: Each
Checked & Approved By	:	1/8 080313		
Comment	Est. A 03.05.26	New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S25GA	304/316 .020" Sheet
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Comment: Qty.: 0.2261 sf(s)/Unit Total : 4.5213 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet

(M304S25GA) M3045266A Batch: 1107021

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LBN

8/3/18

SC, 60x

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

D 08/03/18

Job Completion



2008/3/18

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 01/03/18
 QA: N/C Closed: _____ Date: _____

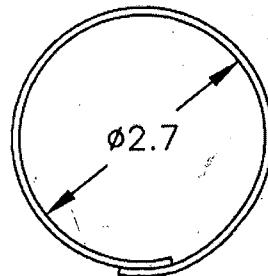
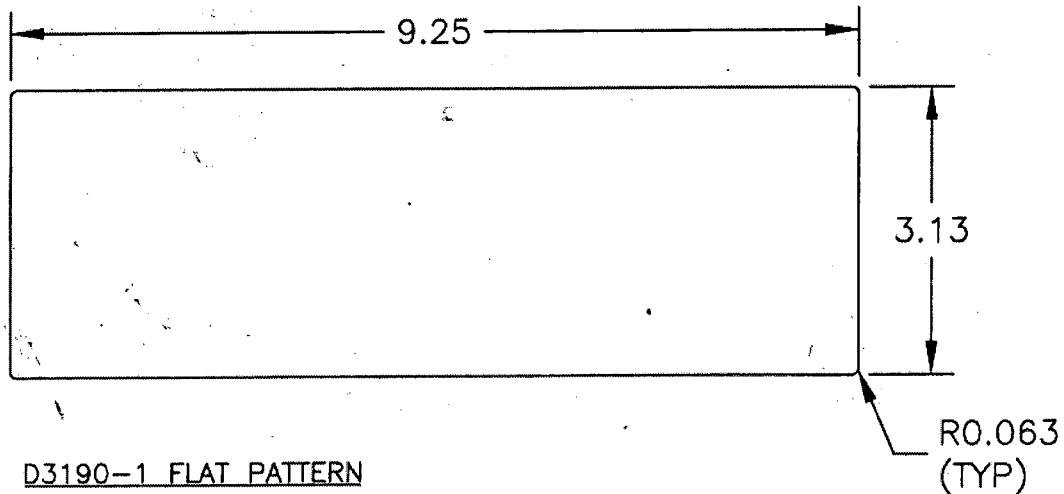
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC. M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37969